

Date: Wednesday, 3/14/2007 3:28:20 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARPLATE		
Job Number	: 31212			Part Number	: D25771		
Estimate Number	: 10288			Drawing Number	: D2577 REV E		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 3/14/2007 S.O. No. : N/A			Drawing Revision	: E		
Prsh Rev.	: NC			Material	: N/A		
First Issue	: 3/14/2007 Type : SMALL /MED FAB			Due Date	: 3/30/2007 Qty: 40 Um: Each		
Previous Run	: 29994						
Written By	:						
Checked & Approved By	:						
Comment	: Est: E 02.09.24 Re-format; Incorporated D2577-101-11KJ/ RF est F 06.09.11 now waterjet EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
	Comment: Qty.: 0.8474 sf(s)/Unit Total : 33.8940 sf(s) 1010/1025/A21/6aA SHEET	M103069 (10) M103034 M109056 (14) SAD 07/05/09
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET	
	1-Cut as per Dwg D2577 (D2577-101 detail)	
	Dwg Rev: E	
	Prog Rev: E	
	2-Deburr if necessary	
		ml 07/05/10 32
		SAD 07/05/09
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/05/09
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	MS on 105/09
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE	
	1-Form on brake as per Dwg D2577 using DT8155 and DT8179	
	2-Form joggle as per Dwg D2577 using DT8157	
	3-Identify as D2577-1	
	4-Deburr if nessasary	
		SB 07/05/25 32
		JM 07/05/14 32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/18/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:28:20 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 31212

Part Number: D25771

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



*Petoskey*



Comment: INSPECT WORK TO CURRENT STEP

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description Batch  
A/R 7560 Hardcoat Rod m104368 m104221

*FC 07/06/07 (32)*

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*m101601 DR/FK, 07-06-11 (32)*

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-d 07/06/13 (32)*

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP-16*

*16 07-06-13 (32)*

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*12 07/06/14*

Job Completion



*14 07-06-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

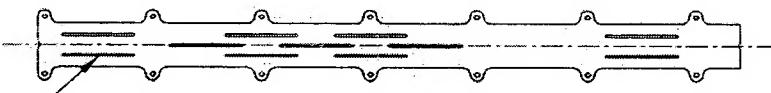


DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
A	96.09.16	DRAWING NO. D2577
B	96.12.04	REV. E SHEET 1 OF 5
C	97.05.30	SCALE
D	98.08.17	WEARSHOE
E	00.09.22	WEARSHOE

**RELEASED**

Rev. D 9 26 97

7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



### D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

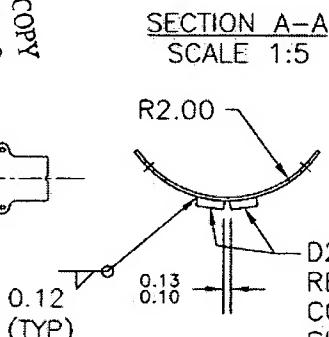
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300  
SHWAYDER WEAPADS  
(8 PLACES)

A  
A

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NO. 31212

1.50 (TYP)



D2941-300 (REF)  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

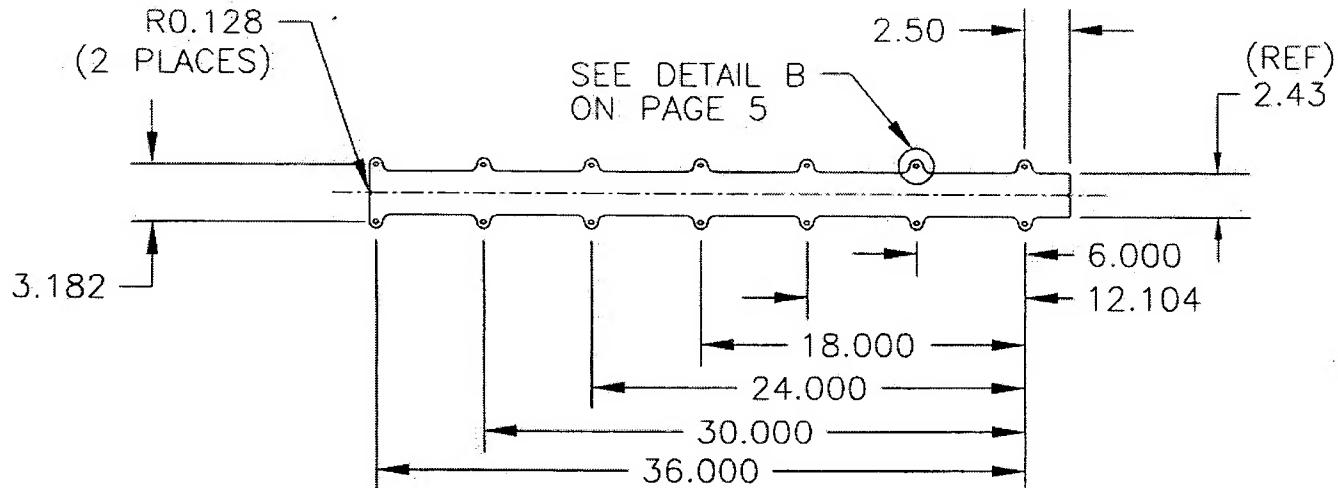
### D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
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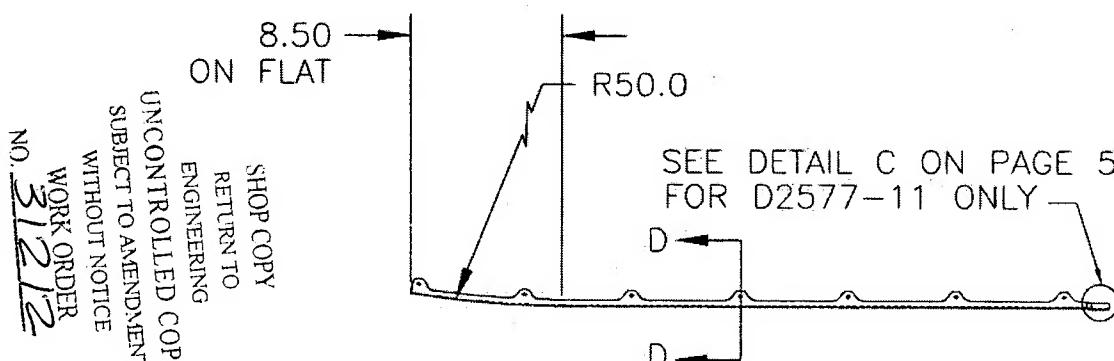


**D2577-101 FLAT PATTERN**

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**D2577-11 & D2577-13 LONGITUDINAL BEND**

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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4	G	REV. E
CHECKED	APPROVED	DRAWING NO. D2577

DATE  
00.09.22

TITLE  
WEARSHOE

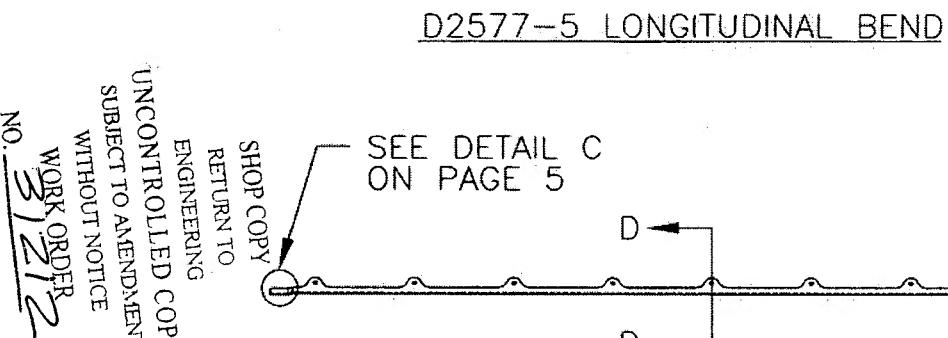
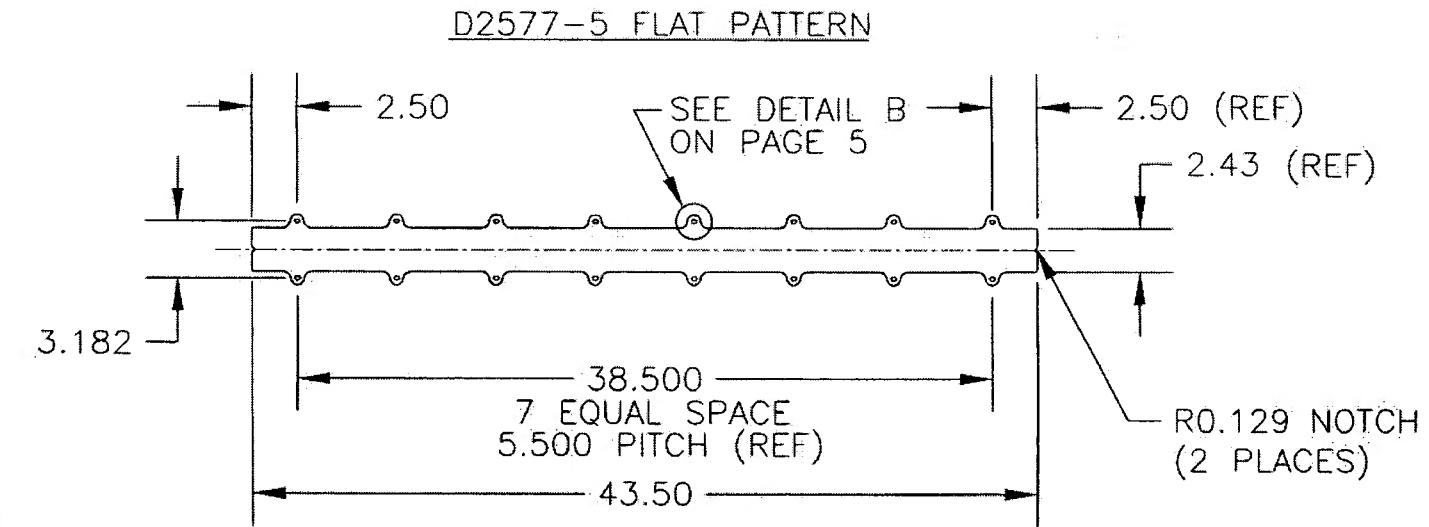
SCALE  
1:10

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04.04.26

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NO. 31212



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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4	H	D2577
DATE		SHEET 3 OF 5
00.09.22		WEARSHOE
SCALE		1:10

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00.01.26 44

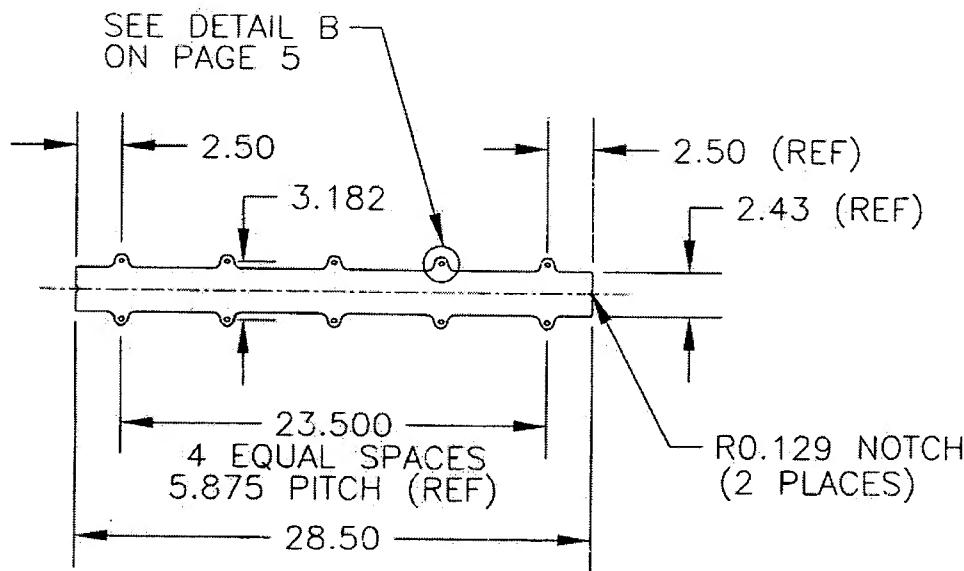
**DART**



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CHECKED	APPROVED	DRAWING NO. D2577	SHEET 4 OF 5
DATE	TIME	WEARSHOE	SCALE

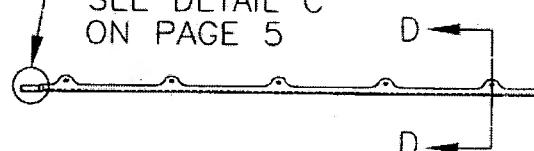
### D2577-7 FLAT PATTERN

SEE DETAIL B  
ON PAGE 5



### D2577-7 LONGITUDINAL BEND

SEE DETAIL C  
ON PAGE 5



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### D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
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09-09-26 47

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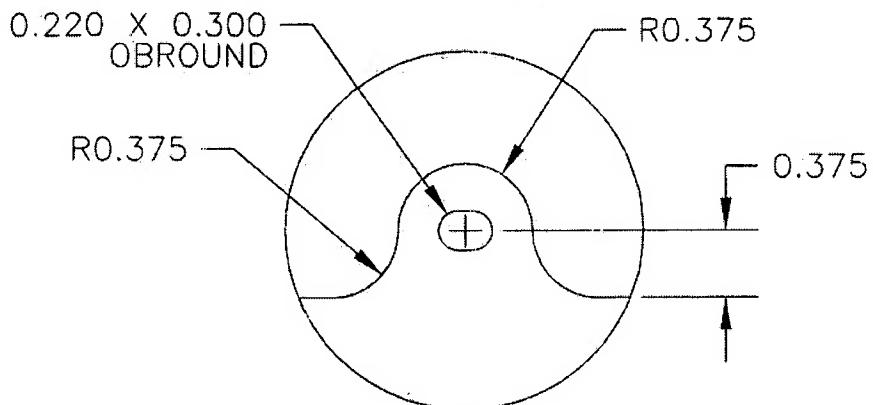


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02/09/2022

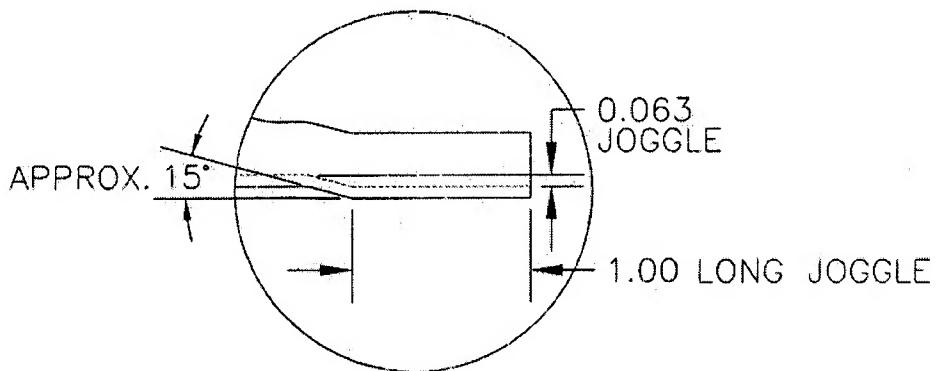
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CHECKED	APPROVED	DRAWING NO.	REV. E
		D2577	SHEET 5 OF 5
DATE		TITLE	SCALE
00.09.22		WEARSHOE	1:10

DETAIL B (SCALE 1:1)

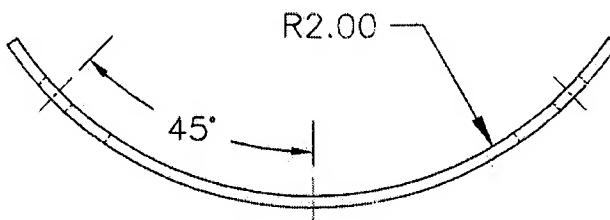
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DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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DART AEROSPACE LTD	Work Order:	31212
Description: <del>Bear paw</del> Wear plate	Part Number:	D25771
Inspection Dwg: D2577 Rev+		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 3.182	+/- 0.010	3.187	✓		Vern	
B 2.43	+/- 0.030	2.44	✓		Vern	
C 0.220	+/- 0.010	0.218	✓		Vern	
D 0.300	+/- 0.010	0.299	✓		Vern	
E 0.063	+/- 0.010	0.060	✓		Vern	
F 36.00 0	+/- 0.010	36.00 0	✓		M-T	
G 30.00 0	+/- 0.010	30.00 0	✓		M-T	
H 24.000	+/- 0.010	24.000	✓		M-T	
I 18.000	+/- 0.010	18.000	✓		M-T	
J 12.104	+/- 0.010	12.107	✓		M-Vern	
K 6.000	+/- 0.010	6.066	✓		<del>M</del> Vern	
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	SAB	Audited by:		Prototype Approval:	N/A
Date:	07/05/09	Date:	07/05/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	